

Date: Tuesday, 18/11/2008 9:47:15 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACER
Job Number :	43519		
Estimate Number :	11845		
P.O. Number :		Part Number :	D2346
This Issue :	18/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2346 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	27361	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	18/11/2008
Written By :		Qty:	10
Checked & Approved By :		Um:	Each
Comment :	Est. G 02.03.05 Re-format to machine in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W035	6061-T6 RD Tube .375 x.035W
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Comment: Qty.: 0.1094 f(s)/Unit Total : 1.0941 f(s)
 6061-T6 Tube .375 x.035W

Material: 6061-T6 (WW-T-700/6) .375 Ø x 0.035 wall.
 Batch 104913 DTP 08/11/18

(10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio FA198
 Deburr

DTP 08/11/18

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DTP 08/11/18

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

N.A 08/11/18

(10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.A 08/11/18

(10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/11/2008 9:47:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 43519

Part Number: D2346

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 8/4/18 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 8/4/18 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/19

Job Completion



MF 08-11-18

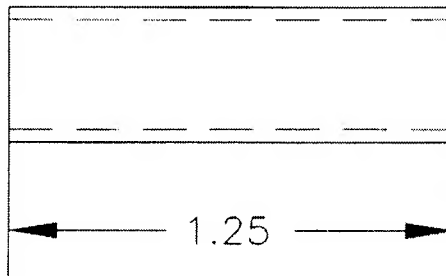


DESIGN BW	DRAWN BY KF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2346	REV. B SHEET 1 OF 1
DATE 99.12.15		TITLE SPACER	SCALE 2:1
A	95.01.05	NEW ISSUE	
B	99.12.15	ADD FINISHING	

RELEASED
19.12.21 03
UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
JB BEFORE MANUFACTURE



W043519

MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA x 0.035 WALL
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK SHARP EDGES 0.010 TO 0.020

DART AEROSPACE LTD	Work Order:	43519
Description: SPACER	Part Number:	D2346
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



x

X

[illegible]

Measured by:	DTP
Date:	08/11/18

Audited by:	H.A
Date:	08/11/18

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	